

Work Order ID 60384

July 7, 2010 8:35:17 AM



Page 1

Item ID: D3773-041

Accept



Setup Start



Revision ID:

Item Name: Headrest Assembly

Start Date: 7/07/10 Start Qty: 10.00



Stop



Required Date: 7/16/10 Req'd Qty: 10.00



Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: CY

QC:

Date: 10/7/7 Tooling:

Date: SPC (Y/N):

Date:

Run Start



Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Draw Nbr	Revision Nbr
D3773	Rev B
110	



Large Fab

Set Up/
Run Hours

Tool ID

Tool #
Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Large Fab

0.00

Large Fab

Memo
1- locate top hole with a 3/16" dowel pin and tack weld D3773-1 adapter to
D3773-3 leg as per dwg D3773 ****take dowel pin out before welding****
2- weld as per dwg D3773 QSI004
316 S.S. Welding Rod Batch: M107213
3- if necessary grind interior of D3773-3 leg flush after welding

0.00

Large Fab

120



QC5- Inspect part completeness to step on W/O

0.00

S.07/22

QC

Quality Control

0.00

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60384

July 7, 2010 8:35:17 AM



Page 2

Item ID: D3773-041

Revision ID:

Item Name: Headrest Assembly

Start Date: 7/07/10 Start Qty: 10.00

Required Date: 7/16/10 Req'd Qty: 10.00

Reference:

Accept



Setup



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start



Stop



Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC9- Inspect visual per QSI004- Fusion Welds

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

(10)

10.07.2010

140



Packaging

Packaging

Identify as per dwg & Stock Location: 249

0.00

10.7-230 (102)

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/07/2010
MF
(0-7-03)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 7, 2010 8:35:15 AM

Work Order ID: 60384

Parent Item: D3773-041

Parent Item Name: Headrest Assembly

Comments: IPP Rev:A 08-05-21 new issue DD verified by:ec
IPP Rev:B 08-07-18 revB as per dwg DD verified by:EC

Start Date: 7/07/10

Start Qty: 10.00

Required Date: 7/16/10

Required Qty: 10.00

Page 1

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3773-1  Adapter		Manufactured	No			110	Each	2.0000	1	10		<i>GPL/10-07-21</i>	

Location	Loc Qty	Loc Code
WA	2	
	2	

Location	Loc Qty	Loc Code
WA	1	
	1	

Location	Loc Qty	Loc Code
WA	2	
	2	

Location	Loc Qty	Loc Code
WA	1	
	1	

B60385 → 10

GPL/10-07-21

B60386 → 10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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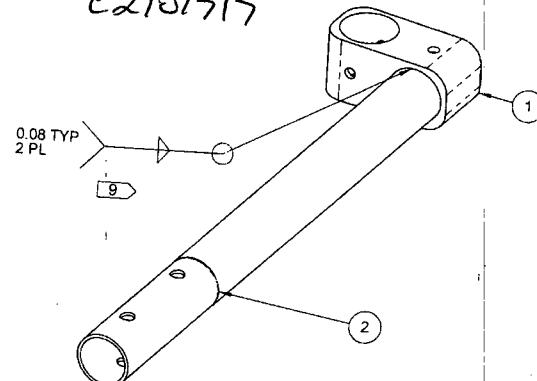
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 60389

c2101717



ITEM NO.	PART NUMBER	DESCRIPTION	QTY
1	D3773-1	ADAPTER	1
2	D3773-3	LEG	1

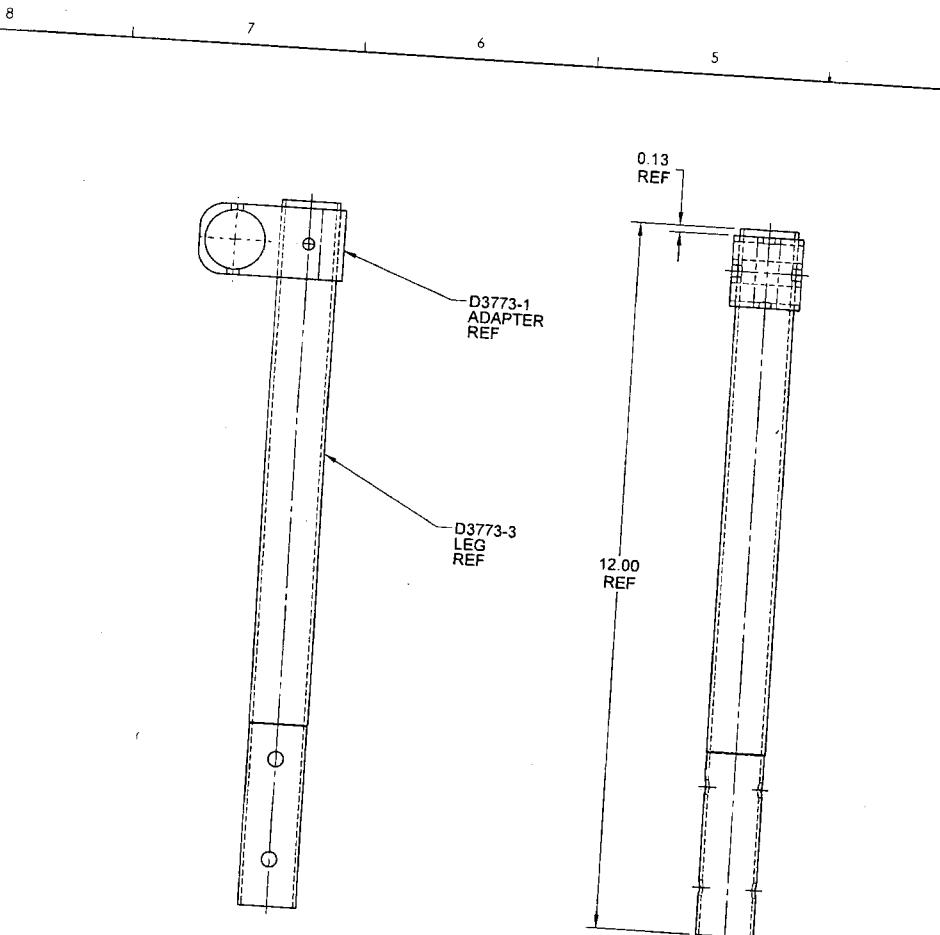
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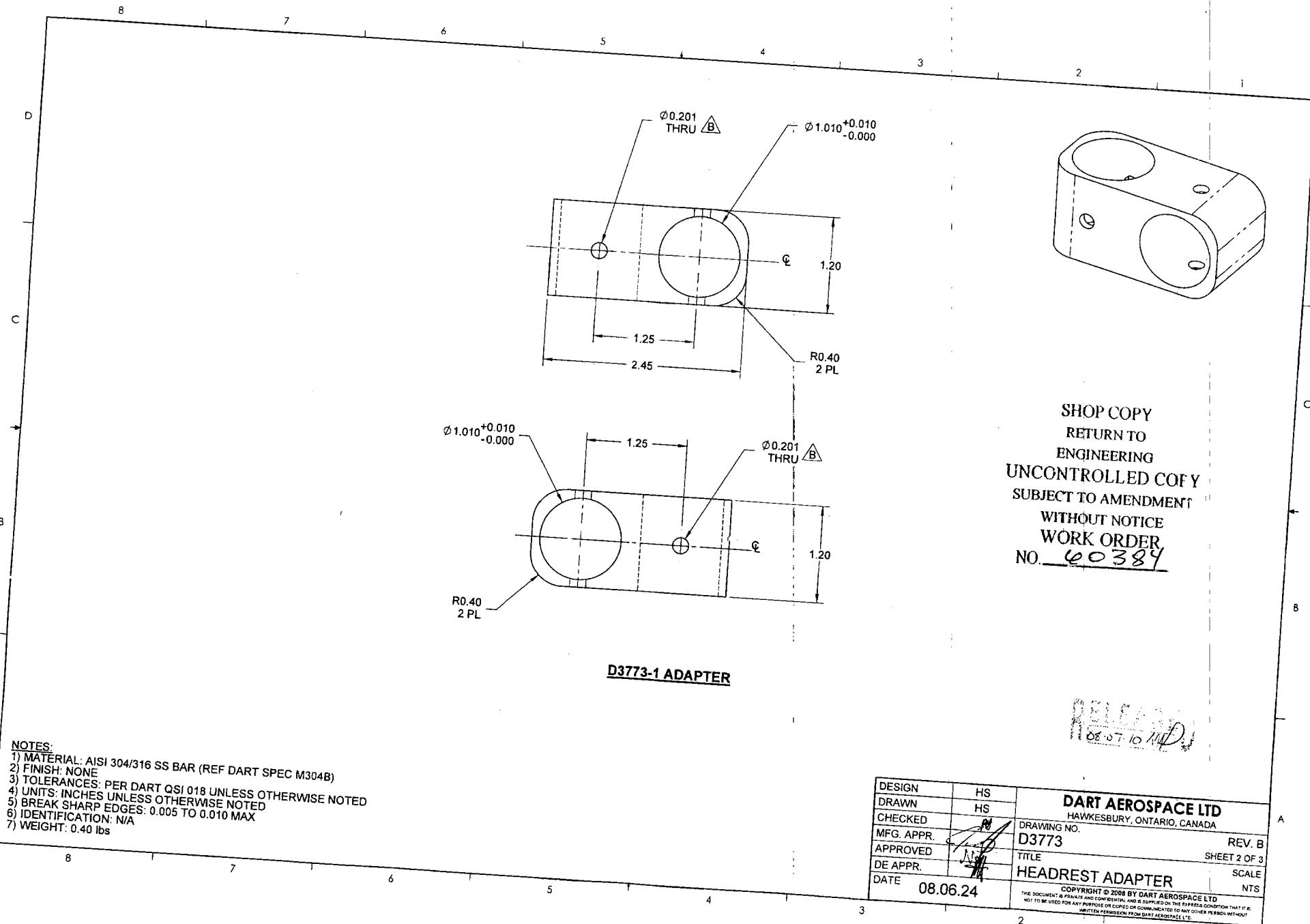
B	CHANGE HOLE SIZE TO 0.201	HS	08.06.24
A	NEW ISSUE	HS	08.06.04
REV.		DESCRIPTION	BY DATE
DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	64	DRAWING NO.	
MFG. APPR.		D3773	REV. B
APPROVED		TITLE	SHEET 1 OF 3
DE APPR.		HEADREST ADAPTER	SCALE
DATE	08.06.24	L NTS	

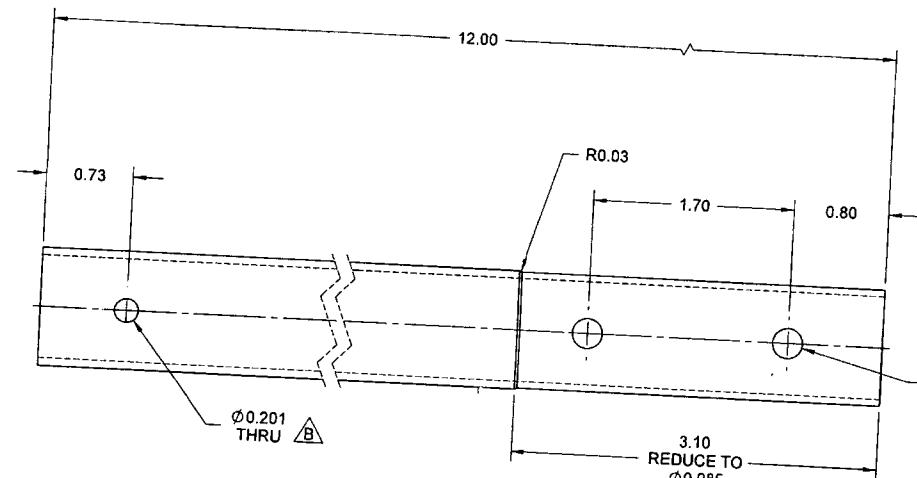
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D3773-041 HEADREST ASSEMBLY

NOTES:
1) MATERIAL: SEE D3773-1/-3
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D3773-1, 0.40 lbs
D3773-3, 0.69 lbs
D3773-041, 1.04 lbs
8) WELD: PER DART QSI 004
9) IF NECESSARY GRIND INTERIOR OF D3773-3 LEG FLUSH AFTER WELDING







D3773-3 LEG

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WORK ORDER

NO. 60384

NOTES:

- 1) MATERIAL: AISI 304/316 SS TUBING 1.00" OD X 0.065" WALL (REF DART SPEC M304TR1.000X.065)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.69 lbs

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3773	SHEET 3 OF 3
APPROVED		TITLE	HEADREST ADAPTER
DE APPR.		DATE	NTS
		08.06.24	

*RECEIVED
08-07-10 MHD*

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